

# Work Order ID 52555

September 30, 2009 11:28:43 AM



Page 1

Item ID: D2672

Accept



Setup Start



Revision ID: B1

Stop



Item Name: Bearpaw 13" X 24", 206

Start Date: 30/09/2009 Start Qty: 8.00



Cust Item ID:

Required Date: 16/10/2009 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: *PL*

Date: *09-9-30*

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2672

Rev B1

120

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut Blank as per File D2672\_BLANK

*B 9-10-10*

*9*

130

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining  
2-Machine as per Folio FA791 and Dwg D2672. Identify as D2672  
3-Deburr

*DIT 09/10/13*

*9*

140

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*DIT 09/10/14*

*9*

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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC8- Inspect parts - second check

0.00

SL 09/10/14



QC

Memo

0.00

Quality Control

180

Identify as per dwg &amp; Stock Location: PPP

0.00



Packaging

Packaging

Memo

52554

0.00

Packaging

09/10/15 (9)

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/15

MF  
09-10-15

# Picklist Print

September 30, 2009 11:28:42 AM

Page 1

Work Order ID: 52555



Parent Item: D2672RevB1



Parent Item Name: Bearpaw 13" X 24", 206



Start Date: 30/09/2009

Required Date: 16/10/2009

Comments:

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MUHMWB10 		Purchased	No			120	sf	523.2231	28.8000			
UHMW 1" Black												18 9-10-10

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	446.5752	
112186	126.5752	
112514	200	
112681	120	112681
Main Warehouse		
ST	76.6479	
108762	11	
109186	5	
110520	8	
110721	10.5602	
111354	42.0877	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	52555
<b>Description:</b> Bearpaw		<b>Part Number:</b>	D2672
<b>Inspection Dwg:</b> D2672	<b>Rev:</b> B1	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	23.750	+/-0.030	23.75	✓			
B	12.750	+/-0.030	12.75	✓			
C	4.250	+/-0.010	4.250	✓			
D	2.000	+/-0.030	1.998	✓			
E	9.000	+/-0.010	9.00	✓			
F	0.375	+/-0.030	0.380	✓			
G	9.000	+/-0.010	9.00	✓			
H	Ø0.260	+0.005/-0.000	0.260	✓			
I	Ø0.93	+/-0.030	0.923	✓			
J	0.300	+0.030/-0.000	0.316	✓			
K	0.625	+/-0.030	0.626	✓			
L	0.063 x 45°	+0.030/-0.010	0.065 x 45°	✓			
M	0.250	+/-0.010	0.245	✓			
N	5.500	+/-0.030	5.505	✓			
O	R0.250	+/-0.030	0.250	✓			
P	0.200	+/-0.030	0.2005	✓			
Q	0.25 x 45°	+/-0.030	0.280 x 45°	✓			
R	0.950	+0.030/-0.010	0.9425	✓			
S	0.375	+/-0.010	0.3695	✓			

<b>Measured by:</b>	DJP	<b>Audited by:</b>	JL	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	8/10/13	<b>Date:</b>	09/10/14	<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue	KJ/RF	

**DART**



DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
LE	LE	DRAWING NO.	REV. B
CHECKED	APPROVED	D2672	SHEET 1 OF 2
DATE	TITLE	SCALE	
98.05.19	BEARPAW	1:5	
A	97.04.08	NEW ISSUE	
B	98.05.19	CHANGE C'BORE, R1.58 WAS R1.50	
B1	02.10.22	Ø0.93 WAS Ø0.75	

ENGRAVE LOGO TO  
MAX DEPTH OF  
0.012. ENGRAVE  
PART AND BATCH  
NUMBERS TO MAX  
DEPTH OF 0.010.  
(TYPICAL LOCATION  
AS ILLUSTRATED)

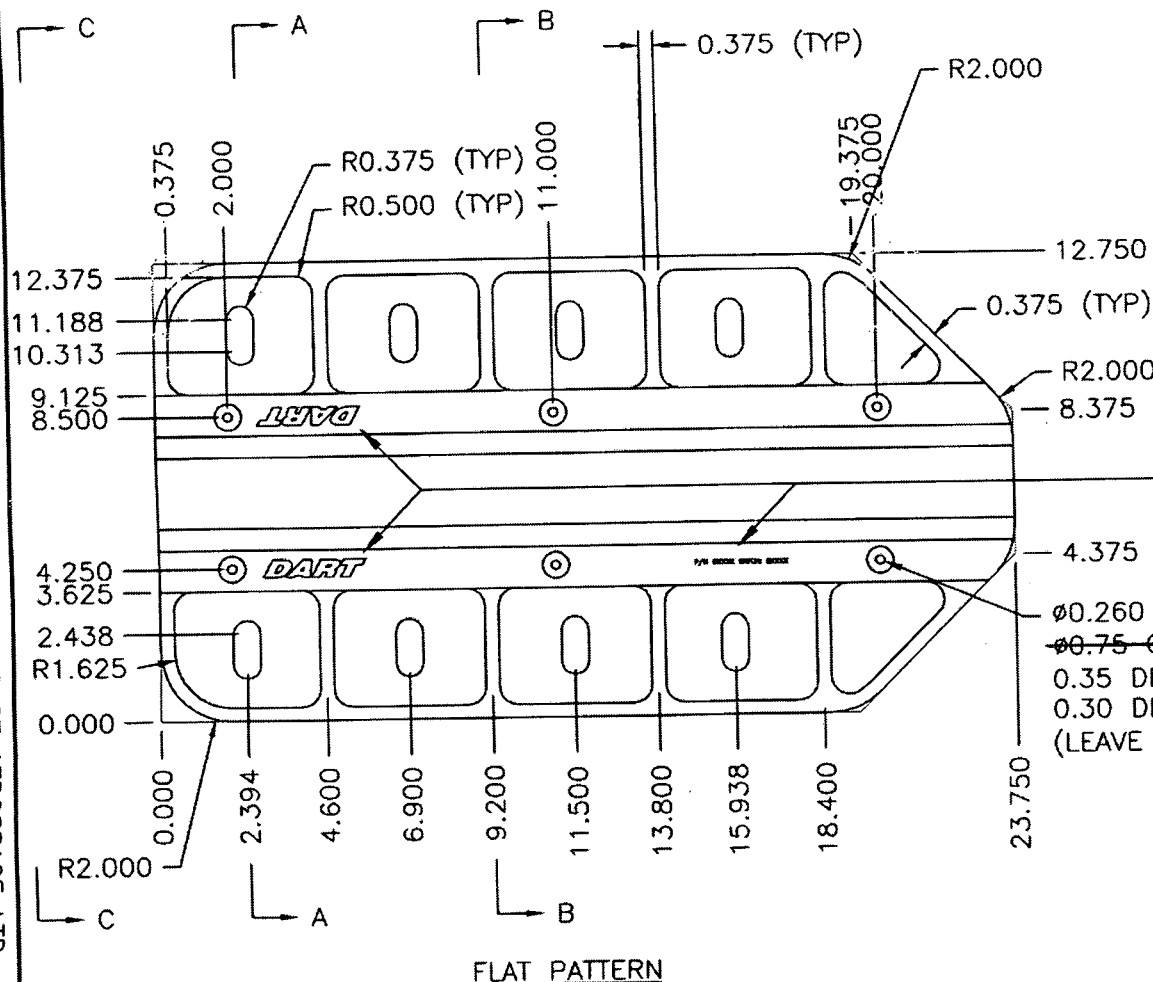


Ø0.260 (TYP)  
~~Ø0.75 C'BORE~~ Ø0.93 C'BORE  
0.35 DEEP FROM TOP (MIN.)  
0.30 DEEP FROM BOTTOM  
(LEAVE 0.300 MIN.)

EFFECTIVE DEOS

9143	
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**RELEASED**  
98.06.17 KS



MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689  
1.00 THICK (MACHINE TO 0.950)

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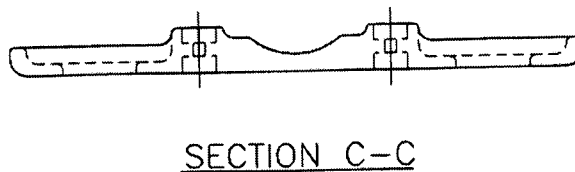
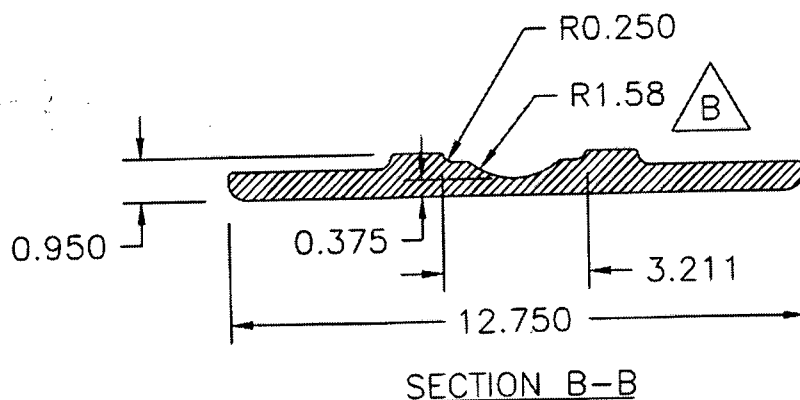
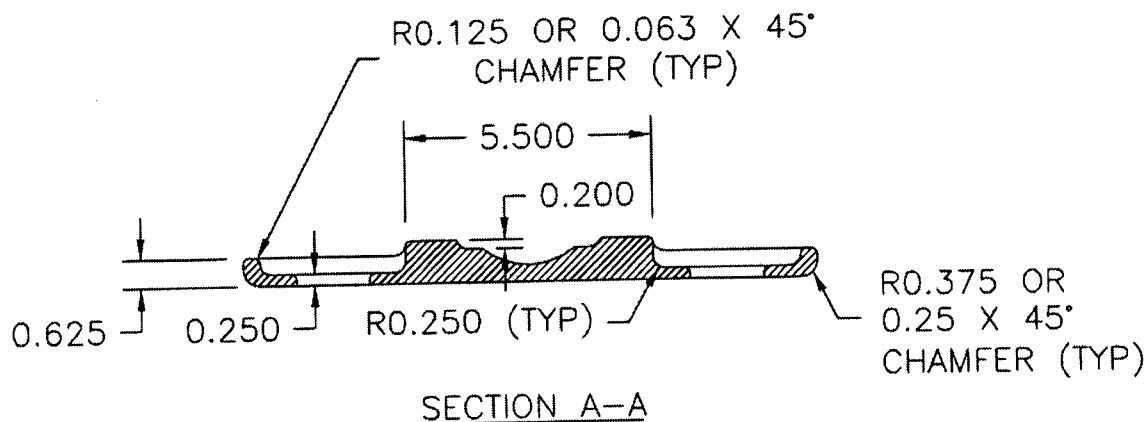
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 58855

Ref 08-9-30



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>mm</i>	APPROVED <i>JS</i>	DRAWING NO. D2672	REV. B SHEET 2 OF 2
DATE 98.05.19	TITLE BEARPAW		SCALE 1:4

RELEASED  
98.06.17 KE



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